

Ship 14/03




Date: Tuesday, 3/11/2008 7:31:31 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS ASSEMBLY
Job Number : 37700	
Estimate Number : 12867	
P.O. Number :	Part Number : D412702045B
This Issue : 3/11/2008 S.O. No. :	Drawing Number : IIN D412-702 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL/MED FAB	Drawing Revision : E
Previous Run : 37314	Material :
Written By : JP 08/03/11	Due Date : 3/14/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : est rev A 07.05.10 new issue EC Est Rev:B 07-07-06 As per Rev E JLM	

Additional Product

Job Number: 

Seq. #	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		  AS 08-03-13
	Comment: DOCUMENT CONTROL	
	Photocopy bluefile & type labels per PPP D412-702-045B CHG002	08/03/13
2.0	D412702111B	HARNESS ASSEMBLY
	 	
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)	
	HARNESS ASSEMBLY	B37712 New Batch AS 08/03/13 (X)
3.0	D412702113B	HARNESS ASSEMBLY
	 	
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)	
	HARNESS ASSEMBLY	B37713 New Batch AS 08/03/13 (X)
4.0	D3572041	GUIDE ASSEMBLY
	 	
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)	
	GUIDE ASSEMBLY	B31870 AS 08/03/12 (X)
5.0	AN416A	Bolt
	 	
	Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)	
	Bolt	M19270 AS 08/03/12 (X)
6.0	AN425A	BOLT
	 	
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)	
	BOLT	M104438 AS 08/03/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ID Date: 08/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:31:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 4-MAN 3-POINT AFT FACING SHOULDER HARNESS
ASSEMBLY

Job Number: 37700

Part Number: D412702045B

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

batch:

M106277

AS 08/03/12

(X)

8.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch:

M105938

AS 08/03/12

(X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-045B CHG001

Location:

PPP Rev:

B

8/03/13

SO

(X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/13 (1)

Job Completion



2008/03/13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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NO. 37700

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

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Revision: E

Date: 07.06.27